

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-001475**Date Inspected:** 15-Feb-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 800**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1500**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai China

CWI Name:	Xu Jing Long			CWI Present:	Yes	No	
Inspected CWI report:	Yes	No	N/A	Rod Oven in Use:	Yes	No	N/A
Electrode to specification:	Yes	No	N/A	Weld Procedures Followed:	Yes	No	N/A
Qualified Welders:	Yes	No	N/A	Verified Joint Fit-up:	Yes	No	N/A
Approved Drawings:	Yes	No	N/A	Approved WPS:	Yes	No	N/A
				Delayed / Cancelled:	Yes	No	N/A
Bridge No:	34-0006			Component:	Tower 89m mock-up		

Summary of Items Observed:

This Quality Assurance (QA) Inspector arrived at ZPMC for observation of the 89m mock-up in the tower shop for corner stiffener plates fitted to skin plates B and C. This QA Inspector observed ZPMC performing a weld repair on plate Sa 184 for the rejectable indication noted in report dated 2-14-08. Welding Procedure Specification (WPS) number; WPS-B-T-2231-B-U2a-F was witnessed as being applied at this location by this QA Inspector. ZPMC Quality Control (QC) inspector Xu Jing Long and Xu Le Feng was observed as being present during the repair process and monitoring the progression and welding parameters. This QA Inspector verified the welding parameters of ZPMC welding personnel Pang Meng as follows; 297 amps, 29.3 volts and travel speed of 300mm/min. The preheat temperature was recorded as minimum 65°C with a maximum of 230°C as required by the WPS. Once the repair was completed ZPMC has allowed the part to cool to ambient temperatures and will perform re-examination with ultrasonic testing the following day. ZPMC personnel proceeded with the fit-up of plate Sa194 to skin plates B & C in accordance with the contract documents for placement. This QA inspector observed ZPMC adjusting the plate with grinding to achieve a proper fit-up and root tolerances ZPMC worked on the fit-up for the remainder of this QA Inspectors shift. The work performed above appeared to be within the general requirements of the contract documents. See digital photos below for ZPMC welding personnel performing weld repair and ZPMC QC personnel monitoring welding parameters.

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Summary of Conversations:

This QA inspector spoke with ZPMC QC personnel Xu Le Feng in regards to the repair process and was informed that ZPMC would perform a ultrasonic examination on the repair weld tomorrow.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials for your project.

Inspected By:	Riley, Ken	Quality Assurance Inspector
Reviewed By:	Cochran, Jim	QA Reviewer
